Work Orde		1043					,	Page 1				
Revision ID:	D4016-3 Hinge Half, Li	d	20.0 4	Accept	*N900	040	100)*	Setup	Start Stop	ı Vı,	S1* S2*
Start Date: Required Date: Reference:	5/10/13 5/10/13	Start Qty: 5.00 Req'd Qty: 5.00	*5* *5*		Cust Item II Customer:	D:	·	•				
Approvals:		n: MLJ	Date: <u>13^05-02</u>	Tooling: _ SPC (Y/N):		te:			Run	Start Stop	I <i>V</i> 1	R1* R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr										1,
D4016	A									·		
100		Cut blanks as per folio		0.00				DAr				_
100 Bandsaw Jeaspa Bandsaw		Memo CUT BLAN	K as per folio	0.00			ی	04s 02 47		13	-05	-13 (x2
110	.*		:	0.00					•			
110 HAAS 1 HAAS CNC vertical	I machine #1	Memo MACHINE FOLIO REV DWG REV:		0.00 D DWG		0	L)	NH ²	0 13/	05	16	

DEBURR

V.

											DQA:	Date:	
NCR: Ye	es /	No				WORK ORDER NON-C	100	VFOR	MANCE / UP	DATE			
											QA Closed:	Date:	
Work Order	֥					DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
i	. —					Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part No	o					Scrap		1	Machining	Small Fab	1	d. Eng. Coor.	Quality
NCR No	0			······································		Use-as-is Work Order Update		Thern	noforming Large Fab	Finishing Composite	Rec/Stoi	re/Packaging Supplier	Other
Root					Descri	ption of work order update		Initial	Ac	tion	Sign &	·	
Cause	Da	ate	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator							1						
Material									1				
Setup													
Other				ļ									
Process					57								

Landin	g Gear	General	 _	_		_
Γ	Bending	Bend	Grain	Ovalized		Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance		Temperature/Cure
ſ	Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect	L	Weld
Γ	Crushed/Crimped	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing		Wrong Stock Pulled
	Cuffs	Contamination	Maintenance	Part Moved		
	Heat Treat	Countersink	Mislabeled	Positioned Wrong		_
	Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge	L	Other ·
	Ripples in Bend	Drill Holes	Offset			
. [Torque Waves in Extrusion	Drawing	Out of Calibration			
	Turning Sequence	Finish	Out of Sequence			
Γ	Wave/Twist in Tube	Folio	Outside Dimensions			

FAULT CATEGORY

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Supplier Training Unapproved Work Order ID 101043 *101043* Page 2 April-30-13 2:38:54 PM Accept Item ID: D4016-3 *N900040100* Setup Start **Revision ID:** Item Name: Hinge Half, Lid 5/10/13 **Start Date:** Start Oty: 5.00 **Cust Item ID:** Required Date: 5/10/13 Req'd Qty: 5.00 **Customer:** Reference: Run Approvals: Process Plan: Date: **Tooling:** Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Description **Work Center ID** Code Qty Otv Number Stamp **Run Hours** 120 QC2- Inspect parts off machine FAI/FAIB 0.00 MH B/05/13 20 0 *120* QC 0.00 Memo Quality Control QC8- Inspect parts - second check 130 0.00 FK 13/05/17 26 Ø *120* 0.00 Memo **Quality Control** Identify as per dwg & Stock Location: WA 0.00 160 *160* 0.00 Packaging Memo

Packaging

			DQA:	Date:
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE	0.4 Classed	Data
			OA Closed:	Date:

											QA Closed:	Date	e:
Work Orde	·r·					DISPOSITION		_		AGAINST DE	PARTMENT	/PROCESS	
Part N	 _ No					Rework Scrap Use-as-is Work Order Update] 	l hern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root	П				Descri	ption of work order update	Init	ial	Ac	tion	Sign &		
Cause	- 1	Date	Step	Qty		or Non-conformance	Chief	Eng	Desc	ription	Date	Verification	QC Inspector
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Material													
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Supplier	Ш												
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						F.	AULT (CATE	GORY				
Landi					,	General					1	г	\neg
		Bending				Bend		rain		<u> </u>	Ovalized	L	Pressure/Forced
	-	Centre No	ot Conce	ntric to	o/s	BOM/Route	\vdash	ardwa			Over/Under	F	Temperature/Cure
		Cracks			<u> </u>	Broken/Damaged	-	•	on incomplete		Part Incorred	-	Weld
		Crushed/	Crimped		<u> </u>	Burrs	_		ions Incomplete/	'Unclear	Part Lost/Mi	ssing [Wrong Stock Pulled
	Ш	Cuffs				Contamination	\mathbf{H}		enance	<u> </u>	Part Moved		
	${f H}$	Heat Trea				Countersink	\vdash	islabe		-	Positioned V		_ ·
		Inspection	-	Tube	_	Cut Too Short	\vdash	isread	1		Power Loss/	Surge [Other
	-	Ripples in			L	Drill Holes	-	ffset					
		Torque W			n L	Drawing			Calibration				
	-	Turning S				Finish	\vdash		Sequence				
		Wave/Tw	ist in Tub	oe -	l.	Folio	0	utside	Dimensions				

Work Ore	der ID 10 :38:54 PM	1043		*10			Page	
Item ID: Revision ID: Item Name:	D4016-3 Hinge Half, L	id		Accept	*N900040100*	Setup	Start Stop	*NS1* *NS2*
Start Date: 5/10/13 Start Qty: 5.00 Required Date: 5/10/13 Req'd Qty: 5.00 Reference:		*5* *5*		Cust Item ID: Customer:				
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):	Date: Date:	Run	Start Stop	*NR1* *NR2*

Sequence ID/ Work Center ID 170

Operation Description

Memo

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours** Tool ID

Tool # Plan

Code

0.00

QC

Quality Control

170

0.00

Number Stamp

Insp.

Reject

Reject

Qty

Accept

Qty

Page 3

											DQA:	Date:	·
NCR:	Yes	/ No				WORK ORDER NON-O	100	NFORI	MANCE / UP	DATE	QA Closed:	Date:	
,					•	DISPOSITION				AGAINST DE			
Work Ord Part	•		 			Rework Scrap]	1	Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR	No.					Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	Rec/Stor	re/Packaging Supplier	Other
Root					Descri	ption of work order update		Initial	Act	ion	Sign &	* : * £	
Cause		Date	Step	Qty	,	or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data												ž	
Equip/Tooling												•	
Operator							l						
Material			İ										,
Setup													,
Other			Ì		1								
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Training											•		
Unapproved													,
						F	AUL	T CATE	GORY	. ,			
Land	ing (Gear				General				_	•		-
		Bending			<u> </u>	Bend		Grain		_	Ovalized		Pressure/Forced
	L	Centre N	ot Conce	ntric to	o/s	BOM/Route	L	Hardwa	are		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		4 '	ion Incomplete		Part Incorred	 	Weld
	L	Crushed/	Crimped			Burrs	Instructions Incomplete/Unclear			Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs				Contamination	Maintenance				Part Moved		, .
		Heat Trea	at			Countersink	Mislabeled				Positioned V	<u>. </u>	

Misread Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

April-30-13 2:38:54 PM

Work Order ID:

101043

Parent Item:

D4016-3

Parent Item Name:

Hinge Half, Lid

Start Date: 5/10/13

Required Date: 5/10/13

Start Qty: 5.00

Required Qty: 5.00

Comments:

I[PP REV:A NEW ISSUE 09-11-27 JL VERIFIED BY:DD 10.02.22 verified by:EC

IPP Rev:B as per dwg REV.A DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B1.000X1.000		Purchased	No			100	f	6.6020	0.08	0.4210526	5		
304 bar 1.00 x 1.00									<u>D</u>	b ar	-13-	· o< -	13
				Location		Loc Qty	Lo	c Code	ري م.	3 /	• •		ŕ
				MAT050		6.602							
				12534	40	6.602			<u>× 2</u>				

					DQA: Date									
NCR:	⁄es	/ No				WORK ORDER NON-C	COI	NFORM	MANCE / UPD	DATE	OA Classid	Dot	_	
								f			QA Closed:	Dat	e:	
Work Orde	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
***************************************	-					Rework	1		Skid-tube	Crosstube	I	Water Jet		Engineering
Part I	۷o.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.		Quality
	-		***************************************			Use-as-is	1	Thern	noforming	Finishing	Rec/Sto	re/Packaging		Other
NCR I	No.					Work Order Update]		Large Fab	Composite]	Supplier		
Root					Descri	ption of work order update		Initial	Acti	ion	Sign &			
Cause		Date	Step	Qty	C	or Non-conformance	Ch	nief Eng	Descri	iption	Date	Verification		QC Inspector
Doc/Data	Ĺ											,		
Equip/Tooling	Ш		:											
Operator	Ш													
Material	Ш											1		
Setup	Ш													
Other			<u>.</u>											
Process	Ш													
Supplier	Ц													
Training	Ш													
Unapproved	Ш													
						FAULT CATEGORY			GORY					
Landi					_	General		_	1	_	_			
	\vdash	Bending			<u> </u>	Bend	L	Grain		<u> </u>	Ovalized	<u> </u>	_	ressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa		<u> </u>	Over/Under	F		emperature/Cure
	Ш	Cracks				Broken/Damaged		4	on incomplete		Part Incorre		_	Veld
	-	Crushed/	Crimped		Burrs				ions Incomplete/U	Inclear	Part Lost/M	issing		Vrong Stock Pulled
	Cuffs Contamination					Maintenance			Part Moved					
	Ш	Heat Trea	ıt		L	Countersink	Mislabeled			Positioned Wrong				
		Inspectio	n Strip in	Tube		Cut Too Short	Misread				Power Loss/	'Surge	C)ther

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	101043
Description: Hinge Half, Lid	Part Number:	D4016-3
Inspection Dwg: D4016 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.88	+/-0.030	-8785	J		Caliper	cnc-ol
0.13	+/-0.030	.1305	1		caliper	CNC-02
0.250	+/-0.010	. 2485	J		cullper	Cuc-07
₩0.03	+/-0.030	20610	7		caliber	Cnc -07
R 0. 0 3	+/-0.030	1030	/		,	
0.50	+/-0.030	1200S	V		caliper	Cnc -02
0.63	+/-0.030	.628	1		calliper	Cnc-oz
0.563	+/-0.010	, S 6 %	J		caliper	Chc-02
Ø0.257	+0.006/-0.001	° 257	1		caliper	Cnc-az
					33 m	
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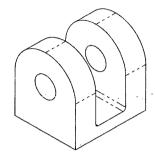
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Measured by: 1	long.	Audited by:	FK	Preliminary Approval	
Date: 13 /	25/16	Date:	13/05/17	Date	

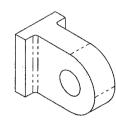
Rev	Date	Change	Revised by ∧	Approved
Α	10.06.07	New Issue	KJ 🛠 📗	X

SHOTONY OT 885 3 3 58 ENGINEE: 4G UNCONTROLLED COPY SUBJECT TO ALTENDMENT WITHOU SOTICE WORK ORDER NU_1.0-1-0-43_MC5

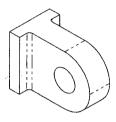
13-05-02



D4016-1 HINGE HALF, BASE



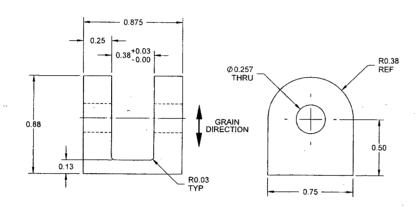
D4016-3 HINGE HALF, LID



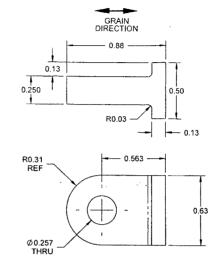
D4016-5 HINGE HALF, LIGHT LID

. A N	NEW ISSUE JPH			JPH.	10.01.29
REV.			DESCRIPTION	BY	DATE
DESIGN		AJS	DART AEROSPACE LTD		
DRAWN		AJS	HAWKESBURY, ONTAI		-
CHECKED)	a	DRAWING NO.		REV. A
MFG. APP	PR.	Z	D4016	5	SHEET 1 OF 2
APPROVE	ED ,	140	TITLE		SCALE
DE APPR		#	BASKET HINGE		NTS
DATE 10.01.29			COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOSIMENT IN PRIVATA MOCEMBRITHING HIS SUPPLIED ON HIS ELFRES CONCRISION THAT IT IS HOT TO ES UTED FOR ANY PURPOSE ON CONCRIDENCE FOR MY COPYER PERSON WITHOUT MITTER PRIVATE HERMISSION FROM DATE ARE ROPACE, TYO TO SEE THE PERSON WITHOUT MITTER PRIVATE HERMISSION FROM DATE ARE ROPACE, TYO TO SEE THE PERSON WITHOUT MITTER PRIVATE HERMISSION FROM DATE ARE ROPACE, TYO THE PERSON WITHOUT THE PERS		

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D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID D4016-5 HINGE HALF, LIGHT LID

DESIGN	AJS	DART AEROSPACE LTD		
DRAWN AJS		HAWKESBURY, ONTARIO, CANADA		
CHECKED	0	DRAWING NO.	REV. A	
MFG. APPR.		D4016	SHEET 2 OF 2	
APPROVED	10	TITLE	SCALE	
DE APPR.	-#	BASKET HINGE	NTS	
DATE 10.0	1.29	COPYRIGHT © 2010 BY DARY AEROSPACE LTD 193 DOCUMENT IS PRANT AND CONFIDENTIAL AND SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY FURBOSE OR COPIED OR COMMUNICATION TO ANY THE REPORT WITHOUT WRITTEN MEMORISM FROM DAY ARROSPACE I'TD		

NOTES: 1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART SPEC M304B

-5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR, PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221 REF DART SPEC M6061T6B

REF DART SPEC M6061T6B

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT -1: 0.09 lbs
-5: 0.01 lbs